

5                    **REACTIVE HYDROXYLATED AND CARBOXYLATED POLYMERS**  
                         **FOR USE AS ADHESION PROMOTERS**

**FIELD OF THE INVENTION**

10            The invention relates to ink compositions containing hydroxylated and carboxylated polymers that are functionalized with reactive metal complexes and alkyl phosphates, which provide adhesion to a wide range of substrates without decreasing the viscosity stability of the composition.

**BACKGROUND OF THE INVENTION**

15            A number of hydroxylated and carboxylated polymers have been found to be useful in imparting adhesion to a variety of substrates, including paper, plastics, metal, and glass. These include polyurethanes, polyurethane-ureas, polyamides, polyesters, polyacrylates, ketone-formaldehyde copolymers, and nitrocellulose that have been used for many years in surface coating formulations. Such materials impart a number of  
20            properties to surface coatings, including adhesion, gloss, pigment wetting, surface hardness, and grease resistance.

                 Typically, substances added to printing inks to promote improved adhesion to substrates (adhesion promoters) cause the ink to undergo an increase in viscosity or completely gel on storage. Since inks need to be of a proper viscosity to perform given  
25            their specific application on press, viscosity increases cause a detrimental effect on the printing process. At the very least, inks that increase in viscosity must be adjusted to lower their viscosity, or in some cases, become unusable altogether. Viscosity stability in inks, with or without the use of adhesion promoters, is something that is required for proper performance.

30            In 1955, an article in *Chemical and Engineering News* reported the use of titanium chelates, a byproduct of pigment manufacture, for formulating heat resistant coatings. These compounds also found utility as additives in nitrocellulose-based printing inks. The most common titanium chelate, titaniumdiacetylacetonate (TiAA), is a reaction product of tetraisopropyltitanate and acetylacetone (AA or 2,4-pentanedione).  
35            This additive and variants thereof are used in formulations throughout the printing ink, paint, and coatings industry. The main disadvantages of its use is:

                 A yellowing of the surface it coats. TiAA is a stable complex and contains, in addition to the two AA groups, two isopropyl groups, which can split off under heat and be exchanged by OH groups in a formulation (OH groups of the nitrocellulose e.g.).

40 The TiAA body is susceptible to reacting with aromatic rings, mainly phenolics present in wood rosin and polyamides forming a deep brownish complex and therefore causes yellowing, especially in white pigmented coating formulations.

Odor. In addition to yellowing, the AA groups can evolve as the surface coating dries. These AA groups have a bitter odor that can be sensed at low concentrations.  
45 Therefore formulators of coatings and inks prefer to completely avoid AA group containing additives in applications such as food packaging.

In order to solve the problems described above, in 1985 non-yellowing and low odor adhesion promoters were developed, a description of these can be found in U.S. Patents 4,659,848 and 4,705,568, and also DE 3525910A1. Materials based on these  
50 promoters have the disadvantage of having too low a reactivity to, for example, give immediate adhesion of an ink to a substrate after a short trigger time in a drying oven on press. In the case of printing inks, this requires the printer to either reduce the web speed through the printing press to achieve higher temperatures (reducing productivity) or increasing the effective temperature inside the drying oven (increasing cost). In  
55 addition, these highly reactive compounds often interact prematurely with other components (resins, pigments, additives) in surface coating or ink formulations, resulting in depletion of their adhesion promoting effect and, even more damaging, an unacceptable increase in the viscosity of the coating or ink formulation prior to application.

60 Based upon these facts, there is clearly a need in the art for additives that promote better viscosity stability, or better adhesion onto substrates, or in the best case, do both with a single additive.

### **SUMMARY OF THE INVENTION**

65 The present invention is new class of reactive polymers or polymer complexes that is the reaction product of at least one polymer containing terminal and/or pendant hydroxyl and/or terminal and/or pendant carboxyl groups, or combinations thereof, with at least one metal complex and at least one alkyl phosphate.

The present invention provides a viscosity stabilizing and/or an adhesion  
70 promoting polymer complex which comprises the reaction product of one or more polymers having a terminal and/or pendant hydroxyl group, or a terminal and/or pendant carboxyl group, and combinations thereof, with at least one metal complex and at least one alkyl phosphate.

75 The present invention also provides an ink or coating composition comprising the reaction product of one or more polymers having a terminal and/or pendant hydroxyl group, or a terminal and/or pendent carboxyl group, or combinations thereof, with at least one metal complex and at least one alkyl phosphate.

80 The present invention also provides a method of stabilizing the viscosity of printing ink, paint or coating composition by adding to said composition a viscosity stabilizing agent which is the reaction product of one or more polymers having a terminal and/or pendant hydroxyl group, or a terminal and/or pendent carboxyl group, or combinations thereof, with at least one metal complex and at least one alkyl phosphate.

85 The present invention further provides a method of improving the adhesion performance of an ink or coating composition by adding to said composition an adhesion promoting polymer complex which is the reaction product of at least one metal complex with one or more polymers having a terminal and/or pendant hydroxyl group, or a terminal and/or pendent carboxyl group, or combinations thereof, and at least one metal complex and at least one alkyl phosphate. With the present invention a lamination bond strength is achieved at a lower level of metal complex.

90 The present invention also provides a method of improving the lamination bond strength of an ink or coating composition comprising adding to said composition an agent which is the reaction product of one or more polymers having a terminal and/or pendant hydroxyl group, or a terminal and/or pendent carboxyl group, or combinations thereof, with at least one metal complex and at least one alkyl phosphate.

95 Other objects and advantages of the present invention will become apparent from the following description and appended claims.

#### **DETAILED DESCRIPTION OF THE INVENTION**

100 It has now been surprisingly found that the adhesion promoting performance of hydroxylated and carboxylated polymers in a printing ink or coating can be enhanced by incorporating additional reactive functional sites on the polymeric backbone of the polymer thereby developing a new class of reactive polymers.

105 This new class of reactive polymers is the reaction product of at least one polymer containing terminal and/or pendant hydroxyl and/or terminal and/or pendant carboxyl groups, or combinations thereof, and at least one metal complex and at least one alkyl phosphate. The new polymer demonstrates unexpected levels of adhesion at lower levels of metal complex when compared to polymeric systems where the

hydroxylated or carboxylated polymer and organometallic or metal containing compounds are added individually to, for example, a surface coating formulation.  
110 Specifically, two distinct beneficial effects have been recognized when these new reactive polymers are used in an ink or coating formulation.

As compared to the individual use of metal complexes alone, the viscosity stability in inks and coatings (especially pigmented systems) is enhanced

As compared to the use of the hydroxylated or carboxylated polymers alone, the  
115 adhesion performance is enhanced and more rapidly achieved in surface coatings, especially under lower temperature drying conditions. In lamination applications improved performance is demonstrated by superior lamination bond strength.

#### **Metal Complex**

120 Preferably, the metal complex is metal orthoester which also preferably has the general formula  $(\text{metal})(\text{OR})_4$  in which R represents an alkyl group which usually contains up to 8 carbon atoms. However, more preferably the alkyl group has 3 or 4 carbon atoms. It is of course possible that mixed alkyl orthometallics may be used such as mixed isopropyl butyl compounds. Most preferably, the metal containing compound  
125 is tetraisopropyltitanate.

#### **Polymer Backbone**

Generally speaking, the hydroxylated or carboxylated polymer used to prepare the reactive hydroxylated polymer can be any polymer having terminal and/or pendant  
130 hydroxyl or carboxyl groups. These can be either natural or synthetic resins, including (but not limited to) polyurethanes, polyurethane-ureas, polyamides, polyesters, polyacrylates, ketone-formaldehyde copolymers, nitrocellulose. These can be polymers suitable for both solvent based and water based coatings.

#### **Alkyl Phosphate**

The alkyl phosphate is used in the reaction to stabilize the polymer complex. Preferably, monoalkyl or dialkyl phosphates are used. The monoalkyl phosphate used will have the general formula  $(\text{R}_1\text{O})\text{PO}(\text{OH})_2$  and the dialkyl phosphate will have the general formula  $(\text{R}_2\text{O})(\text{R}_3\text{O})\text{PO}(\text{OH})_2$ , wherein  $\text{R}_1$ ,  $\text{R}_2$  and  $\text{R}_3$  each independently  
140 represents an alkyl group which can contain up to 10 carbon atoms but preferably contains no more than 5 carbon atoms. Also, preferably  $\text{R}_1$ ,  $\text{R}_2$  and  $\text{R}_3$  are identical

when mixed monoalkyl and dialkyl phosphates are to be used but this need not necessarily be so. Naturally, if desired, the dialkyl phosphate can include different alkyl groups. Most preferably, the alkyl phosphate used is amyl acid phosphate.

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### Example 1 Preparation of Reactive Polymers

#### A. Adhesion-modified hydroxyl functional polyol resin

In a clean, dry reactor under nitrogen, n-propyl acetate (20.93 grams) was charged along with Degussa Synthetic Resin SK (20.94 grams). The resulting reaction slurry was stirred and heated to 50-60°C until all of the resin was dissolved. The reactor temperature was then cooled to 25-35°C. Tetraisopropyltitanate (33.91 grams) was added over 15 minutes and the mixture stirred for 15 minutes. The formation of the intermediate reaction product was followed by monitoring changes in the infrared absorbance of the hydroxyl group at 3400 wavenumbers, where the signal intensity decreased to 11% of the initial signal upon completion of the reaction. Amyl acid phosphate (24.22 grams) was then added over 20 minutes while the reaction temperature was maintained below 60°C. When the addition was complete, the temperature was held at 60°C for 1 hour. Thereafter, the resulting polymer was discharged at a temperature of 25-35°C through a 25 micron filter bag and was observed to have the properties shown below in Table 1.

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**Table 1**

Property:	Value:	Notes on measurements
Appearance	Clear, yellow liquid	
Gardener Color	3 - 5	
Brookfield Viscosity	50 - 150 centipoise	25°C, #3 spindle @ 60 rpm
Percent Solids	58.0 - 62.0%	100°C for 15 minutes using a forced air oven

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#### B. Adhesion-modified acid functional polyurethane-urea

In a clean, dry reactor under nitrogen, a solution of an acid functional polyurethane -urea in n-propanol and n-propyl acetate (1,000 grams) were charged. The material was stirred at 25 - 35°C. Tetraisopropyltitanate (3 grams) was added over 15 minutes and the mixture stirred for 15 minutes. The formation of the intermediate reaction product was followed by monitoring changes in the infrared absorbance of the acid carbonyl group at 3400 wavenumbers, where

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the signal intensity decreased to 62% of the initial signal upon completion of the reaction. Butyl phosphate (2 grams) was then added over 20 minutes while the reaction temperature was maintained below 60°C. When this addition was complete, the temperature was held at 60°C for 1 hour. Thereafter, the resulting polymer was discharged at a temperature of 25-35°C through a 25 micron filter bag.

C. Adhesion-modified acid functional polyamide resin

In a clean, dry reactor under nitrogen, n-propanol (350 grams) was charged, along with Cognis Versamid 972 (an acid functional polyamide resin) (150 grams). The resulting reaction slurry was stirred and heated to 50-60°C until all of the resin dissolved. The reactor temperature was then cooled to 25-35°C. Tetraisopropyltitanate (3 grams) was then added over 15 minutes and the mixture stirred for 15 minutes. The formation of the intermediate reaction product was followed by monitoring changes in the infrared absorbance of the acid carbonyl group at the appropriate wavenumbers, where the signal intensity/absorption decreased by a percentage upon completion of the reaction. Amyl acid phosphate (2 grams) was then added over 20 minutes while the reaction temperature was maintained below 60°C. When this addition was complete, the temperature was held at 60°C for 1 hour. Thereafter, the resulting polymer was discharged at a temperature of 25-35°C through a 25 micron filter bag.

D. Adhesion-modified hydroxyl functional polyester resin

In a clean, dry reactor under nitrogen, a solution of a hydroxyl functional branched polyester in n-propanol and n-propyl acetate (1,000 grams) were charged. The material was stirred at 25-35°C. Tetraisopropyltitanate (0.6 grams) was then added over 15 minutes and the mixture stirred for 15 minutes. The formation of the intermediate reaction product was followed by monitoring changes in the infrared absorbance of the hydroxyl group at 3400 wavenumbers, where the signal intensity decreased to 50% of the initial signal upon completion of the reaction. Butyl phosphate (0.4 grams) was then added over 20 minutes while the reaction temperature was maintained below 60°C. When this addition was complete, the temperature was held at 60°C for 1 hour. Thereafter, the resulting polymer was discharged at a temperature of 25-35°C through a 25 micron filter bag.

Example 2 Preparation of Printing Inks and Testing

A printing ink having the composition detailed in Table 2 was prepared using IA10 adhesion (titanium chelate) promoting agent the synthesis of which is detailed in U.S. Patent No. 4,659,848, herein incorporated by reference. Additional printing inks were prepared using no adhesion promoting agent, synthetic resin SK, combination of IA10 and SK or the reaction product of the present invention as described in Example 1.

Table 2

	INK #1	INK #2	INK #3	INK #4	INK #5
	IA10 only (Comparative)	SK only (Comparative)	Experimental (Example 1 A)	IA10 and SK (Comparative)	Control (Comparative)
Pigment Red 48:2	52.8	52.8	52.8	52.8	52.8
SS nitrocellulose	20.2	20.2	20.2	20.2	20.2
isopropyl acetate	15.4	15.4	15.4	15.4	15.4
denatured ethanol	133.6	133.6	133.6	133.6	133.6
n-propyl acetate	18.0	18.0	18.0	18.0	18.0
Total	240.0	240.0	240.0	240.0	240.0
Disperse and add:					
denatured ethanol	62.6	62.6	62.6	62.6	64.5
n-propyl acetate	19.8	19.8	19.8	20.8	20.4
isopropyl alcohol	15.4	15.4	15.4	15.4	15.8
RS nitrocellulose	15.4	15.4	15.4	15.4	15.8
polyurethane	30.9	30.9	30.9	30.9	31.8
Citric acid	0.8	0.8	0.8	0.8	0.9
wax compound	3.1	3.1	3.1	3.1	3.2
slip compound	7.3	7.3	7.3	7.3	7.5
IA10 (titanium chelate)	4.8			2.8	
Synthetic Resin SK		4.8		1.0	
Example 1 (492- 753)			4.8		
	400.0	400.0	400.0	400.0	400.0

210 Viscosity Stability

Ink samples were tested using a #3 Zahn dip-type efflux viscosity cup. Table 3 illustrates the results.

Table 3

Ink #	Initial Viscosity	Aged Viscosity (16 hours @ 48°C)
1	30 seconds	24 seconds
2	25 seconds	20 seconds
3	30 seconds	20 seconds
4	25 seconds	22 seconds
5	25 seconds	52 seconds

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Adhesion

Test inks 1-5 were reduced to print viscosity (25 seconds @ 25°C in a #2 Zahn dip-type efflux viscosity cup) and were printed on treated polypropylene using a flexographic handproofer. "One Bump" indicates one application of ink. "Two Bumps" indicates two applications of the same ink, one over the other. The results are illustrated in Table 4.

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Table 4

Ink #	Air dried (no heat applied)		Oven dried (10 seconds @ 80°C)	
	One Bump	Two Bumps	One Bump	Two Bumps
1	2	5	1	1
2	2	5	1	2
3	1	4	1	1
4	5	4	1	1
5	5	5	1	4

225 \*1= Best, 5 = Worst

From the above data, the inks of the present invention show superior viscosity stabilization and tape adhesion properties than commercial and prior art inks.

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Example 3

Laminating Inks# 6 and 7 were prepared as detailed in Table 5 using IA10 (titanium chelate) adhesion promoting agent and the reactive polymer product described in Example 1.

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Table 5

Component:	Percent by weight	
	Ink #6 Comparative	Ink #7 Experimental
Titanium dioxide	44.1	44.1
SS nitrocellulose solution	2.9	2.9
polyurethane	31.4	31.4
n-propyl acetate	14.7	14.7
n-propyl alcohol	4.9	4.9
IA10 titanium chelate	2	0
Product of Example 1 A	0	2

Viscosity Stability

The inks were tested using a #3 Zahn dip-type efflux viscosity cup. The results are illustrated in Table 6.

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Table 6

Ink #	Initial viscosity	Aged viscosity (16 hours @ 48°C)
6	30 seconds	60 seconds
7	30 seconds	42 seconds

Adhesion

Inks 6 and 7 were reduced to print viscosity (25 seconds @ 25°C in a #2 Zahn dip-type efflux viscosity cup) and were printed on treated polypropylene using a flexographic handproofer. "One Bump" indicates one application of ink. "Two Bumps" indicates two applications of the same ink, one over the other. The results are illustrated in Table 7.

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Table 7

Ink #	Oven dried (10 seconds @ 80°C)
6	1
7	1

1 = Best; 5 = worst

255 From the above data, the inks of the present invention show superior, viscosity stabilizing than inks containing the adhesion promoter IA10.

#### Lamination Bond Strength

260 The lamination bond strength of a standard, conventional ink formulated from a commercial urethane/urea polymer was evaluated against an ink made with the reactive polymer described in Example 1. These results are shown in Table 8.

Table 8

Substrate	Lamination Bond Strength of Commercial Ink	Lamination Bond Strength of Ink formulated with reactive polymer from Example 1 A.
48 LBT	49	538
Emblem 1500 Nylon	434	572
50 M30	317	685
SP 65	70	186

265 From Table 8, it can be seen that the inks formulated with the reactive polymer from Example 1 have superior lamination bond strength than commercial inks made with urea/urethane resins.

The invention has been described in terms of preferred embodiments thereof, but is more broadly applicable as will be understood by those skilled in the art. The scope  
270 of the invention is only limited by the following claims.